

Date: Monday, 2/25/2008 11:16:03 AM
 User: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : D119 HELI UTILITY BASKET PRELIM
 Job Number : 37592
 Estimate Number : 12452
 P.O. Number :
 This Issue : 2/25/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D119756041
 First Issue : 1 / 1 Type : LARGE FAB ASSY Drawing Number : IIN PG11-12
 Previous Run : 37591 Project Number : N/A
 Material :
 Due Date : 3/17/2008 Qty: 1 Um: Each
 Written By :
 Checked & Approved By : *AS 08 03 26*
 Comment : Est Rev. A New Issue 06-06-14 JLM
 Est Rev. B 06.07.26 dwg revB, picklist EC
 est rev C revC dwg 07.04.09 EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL

*KS 08-03-18*

Comment: Photocopy bluefile & type labels per PPPD119-756-041

CHG-001

AS 08/03/26

2.0 37592A BASKET LID ASS'Y (A119)



Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

ml 08/03/25

3.0 37592B BASKET BASE ASS'Y (A119) PRELIMINARY



Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

ml 08/03/25

4.0 D2022101 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: *33985**AS 08/03/25 (X)*

5.0 D2258220 Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: *30810**AS 08/03/25 (X)*

6.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: *36849**AS 08/03/25 (X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:16:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37592

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 36657

AS 08/03/25 (X)

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 36397

AS 08/03/25 (X)

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 36853

AS 08/03/25 (X)

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 2139

AS 08/03/25 (X)

11.0

D35191

placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

placard

Batch: 29576

AS 08/03/25 (X)

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M106815

AS 08/03/25 (X)

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M102140

AS 08/03/25 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37592

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104937

AS 08/03/25 (X)

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: 104547

AS 08/03/25 (X)

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M107242

AS 08/03/25 (X)

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M106277

AS 08/03/25 (X)

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: 106705

AS 08/03/25 (X)

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: 106054

AS 08/03/25 (X)

20.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M106918

AS 08/03/25 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37592

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: 105442

AS 08/03/25 (X)

22.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M18071

AS 08/03/25 (X)

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M106883

AS 08/03/25 (X)

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106825

AS 08/03/25 (X)

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M106277

AS 08/03/25 (X)

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

ml 08/03/25 (X)

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/25 (X)

25.1 2x D3757-1 (1x) B38068 ~~17500~~ B379015 (-1)
25.2 6x AN310A B ~~17500~~ M14820
25.3 12x AN960J010 B 106552
25.4 6x MS21042L3 B 106883

unable to remove from comp
no Bar codes

AS 08/03/25 (X)

08/03/18

per DST 9405 see attached

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37592

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

29.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CLAMP KIT

Batch: B31741

SP

30.0

D26173

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

B29991

SP

31.0

D26175

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Spacer

B31756 (X) 35977 (X)

SP

32.0

D351611

CLEVIS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

CLEVIS

batch: B31624

SP

33.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

STRUT

Batch: B31628

SP

34.0

D3518041

STRUT ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

FWD ARM ASSEMBLY

Batch: B37621

8/3/25 SP (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37592

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D35201

SPACER



029584

Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER

sq

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M106993

sq

37.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Batch: M106375

sq

38.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M16895

sq

39.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M107013

sq

40.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer
Batch: M106277 (32X) M106780 (8X)

sq

41.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer

8/3/25 sq (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:16:04 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 37592

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer

M17619

SP

43.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut
Batch: M106825

8/3/25

SP

(14)

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8/3/26

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D119
Location: C
PPP Rev: C

8/3/26

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

8/3/26

Job Completion



8/3/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

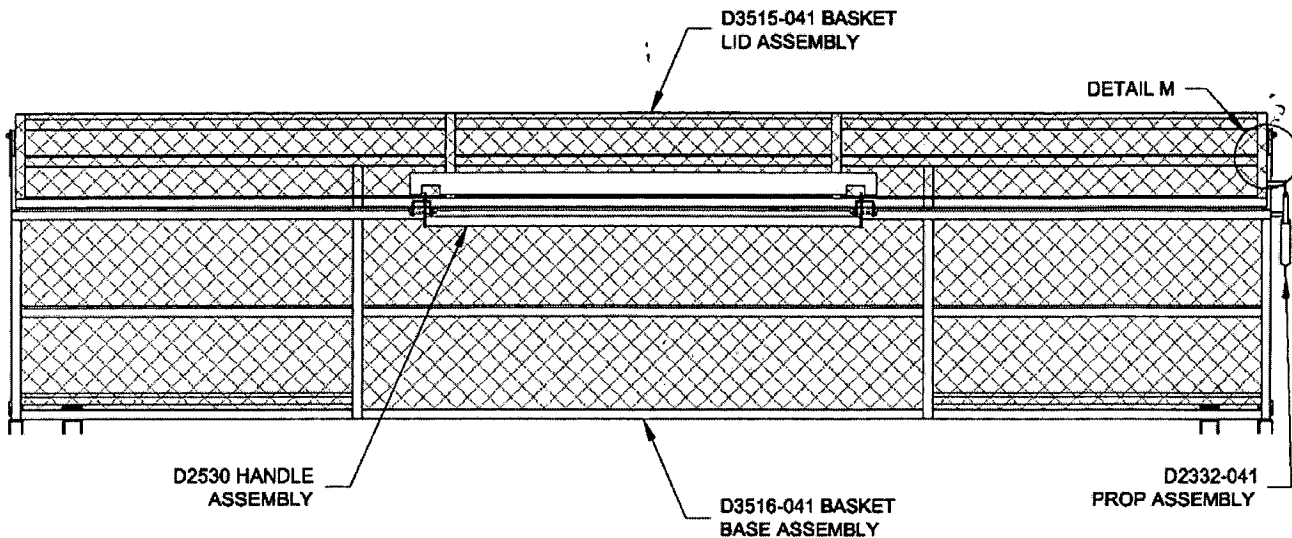
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

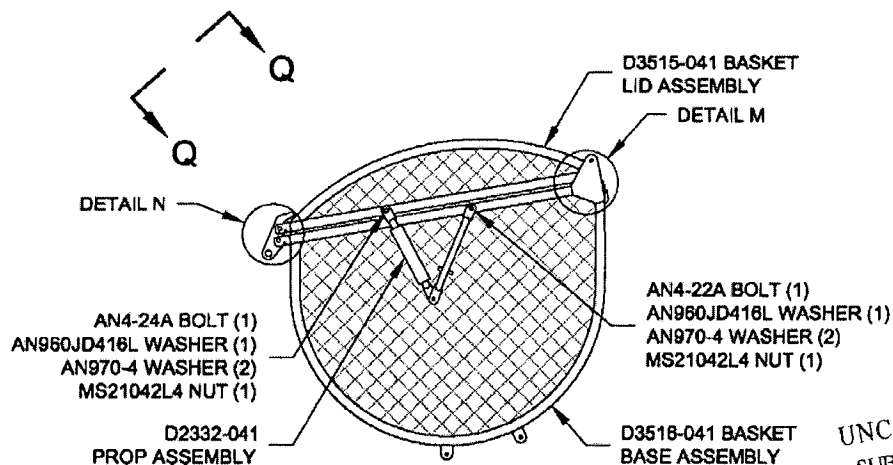
NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart *Heli-Utility-Basket™* which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.



**D119-756-041
HELI-UTILITY-BASKET**



**VIEW C-C:
PROP ARM DETAIL**

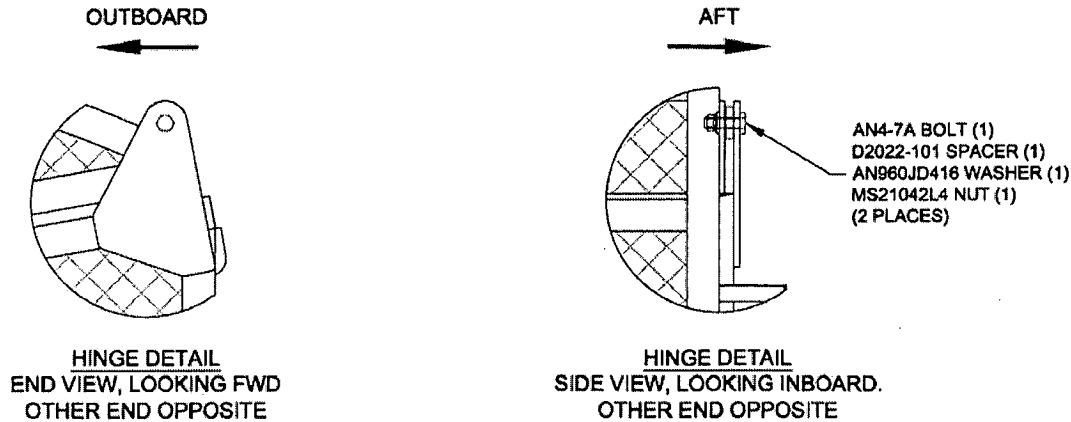
**Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)**

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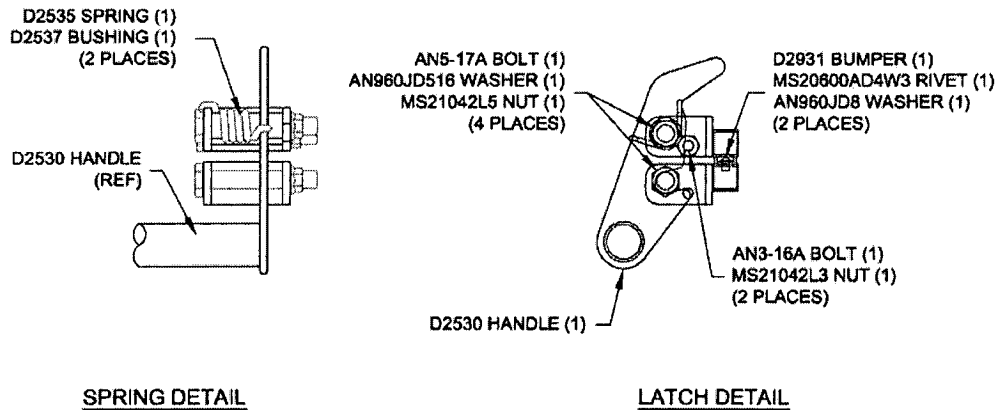
Revision: **C**

Date: 06.10.23

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37582



DETAIL M: HINGE



DETAIL N: HANDLE WELDMENT

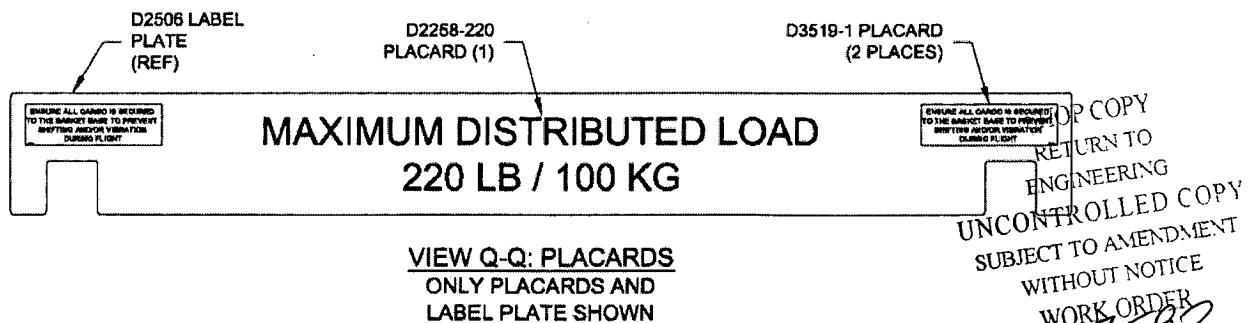


Figure 5 – Basket Replacement Parts & Placards
(D119-756-041 Heli-Utility-Basket™)

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D119-756 REV. C &
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D119-756 REV. 0

REF. TCCA STC SH06-39

REF. FAA STC SR02364NY

ON THE D119-756-041 HELI-UTILITY-BASKET AT CHG 002 OR LATER, THE FORWARD AND AFT ENDS OF THE D3516-041 BASKET BASE ASSEMBLY HAVE BEEN UPGRADED WITH HOOPS AND FITTED WITH D3757-1 BLANKING PLATES. THE D3757-1 BLANKING PLATES MUST REMAIN INSTALLED OVER THE OPENINGS AT THE FORWARD AND AFT ENDS OF THE BASKET. REFER TO FIGURE 1 ON SHEET 2 OF THIS SERVICE INSTRUCTION.

THE PARTS LIST ON PAGE 14 OF IIN-D119-756 REV. C AND ON PAGES 41 AND 43 OF ICA-D119-756 REV. 0. SHOULD BE UPDATED AS FOLLOWS:

QTY -041	PART NUMBER	DESCRIPTION
X	D119-756-041	HELI-UTILITY-BASKET™
2	D3757-1	BLANKING PLATE
6	AN3-10A	BOLT
12	AN960JD10	WASHER
6	MS21042L3	NUT (OR MS21042-3)

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WITHOUT NOTICE
WORK ORDER

PRELIMINARY ISSUE 37592
4 08.02.22

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: _____
D. SHEPHERD (DE # 02)

DATE: 08.02.22
CERT. NO.: SH06-39
ISSUE NO.: 1

A	NEW ISSUE	MB	08.02.22
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9403	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASS'Y CHANGE	NTS
DATE	08.02.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

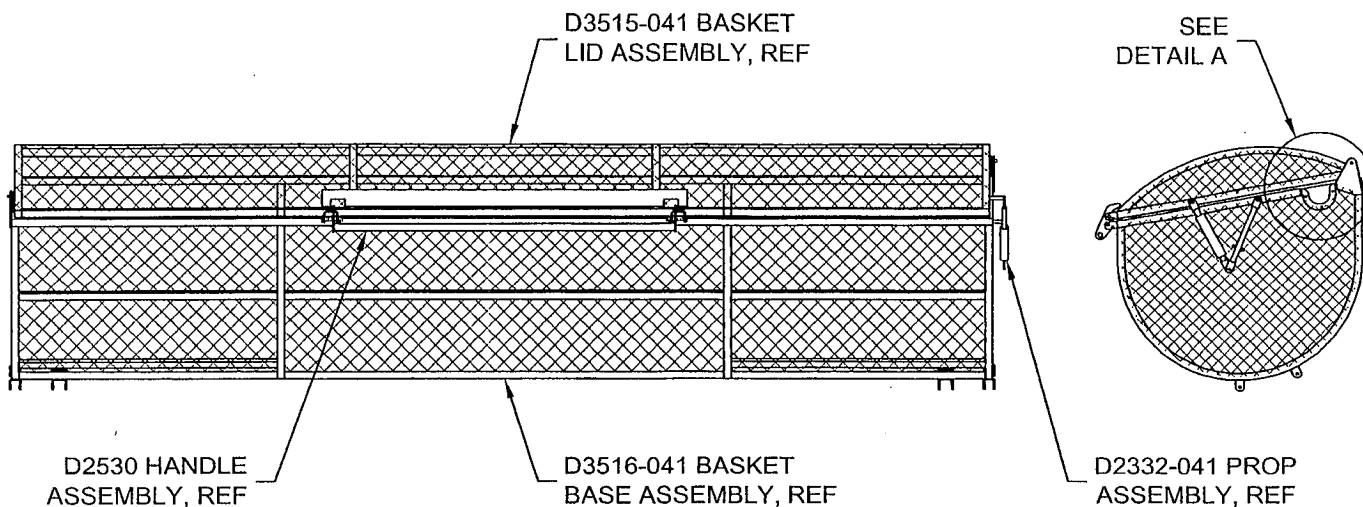
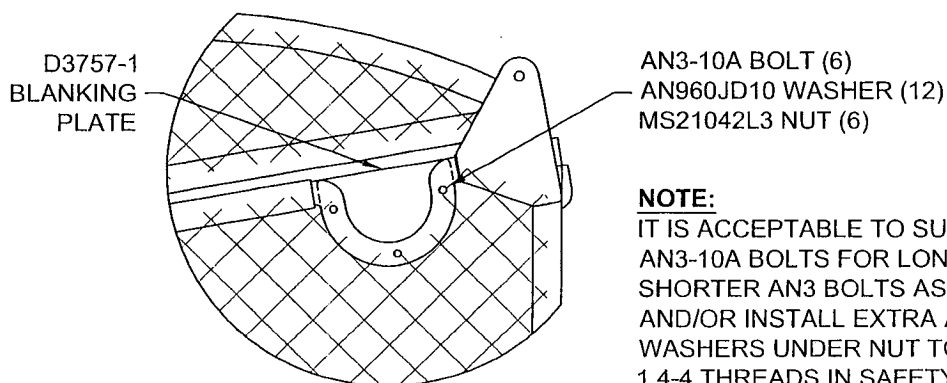


FIGURE 1 - D119-756-041 HELI-UTILITY-BASKET



DETAIL A - HOOP
SCALE 4X
TYP, BOTH ENDS

NOTE:

IT IS ACCEPTABLE TO SUBSTITUTE THE AN3-10A BOLTS FOR LONGER OR SHORTER AN3 BOLTS AS REQUIRED AND/OR INSTALL EXTRA AN960JD10 WASHERS UNDER NUT TO ENSURE 1.4-4 THREADS IN SAFETY.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
37592

PRELIMINARY ISSUE

08.02.22

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. SHEPHERD (DE # 02)

DATE: 08.02.22

CERT. NO.: SH06-39

ISSUE NO.: 1

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		DSI 9403	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASS'Y CHANGE	NTS
DATE	08.02.22	COPYRIGHT © 2007 BY DART AEROSPACE LTD	
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Date: Monday, 2/25/2008 11:16:22 AM
 User: Kim Johnston

Process Sheet

12

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BASKET BASE ASS'Y (A119) PRELIMINARY
Job Number : 37592B	
Estimate Number : 12431	
P.O. Number :	Part Number : D3516041
This Issue : 2/25/2008 S.O. No. :	Drawing Number : D3516 REV C PREMIL
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY	Drawing Revision : C
Previous Run : 37591B	Material :
Written By : <u>JA 08 02 26</u>	Due Date : 3/17/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JA 08 02 26</u>	
Comment : EST rev. A 06.05.31 Preliminary EC	
EST rev. b 06.07.27 updated EC	
Est Rev:C 08-02-25 ECN 1138P DD verified by:	



Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D34421 Shim



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Shim

Batch: B34610

PD 08-03-14

2.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B36481

PD 08-03-14

3.0 D351611 CLEVIS



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

CLEVIS

batch: B31626

PD 08-03-14

4.0 D351613 CLEVIS



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

CLEVIS

batch: B31801

PD 08-03-14

5.0 D23273 Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B36479

PD 08-03-14

W/O:		WORK ORDER CHANGES					
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Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37592B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D22323

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B36846

PD 08-03-14

7.0

D31661

Basket Hoop



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

RIB

Batch: B37611

LS 08/03/12

8.0

D37251

HOOP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

HOOP

batch B37626

PD 08-03-14

9.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M106199 → 11.375 f M107315

LS 08/03/12

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5- Cut rib D3516-15 as per dwg D3516

6-Cut rib D3516-9 from D3166-1 (4)



LS 08/03/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:16:22 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37592B

Part Number: D3516041

Job Number:



POSITIVE RECALL

Seq. #:

Machine Or Operation:

Description:

EFFECTIVE 08/03/17 AUTH

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1

RELEASED

DATE



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3516

08-03-14

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/17 08/03/18

13.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total: 60.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M104218

FC

08 03 18

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

FC

2-Cut expanded metal for base ends as per dwg D3516

FC

3-Weld expanded metal to base as per dwg D3516

FC

08 03 18

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08-03-20

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-03-20

17.0

POWDER COATING

POWDER COATING



M107005



(X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M-1 08/03/24

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-24

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:16:22 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119) PRELIMINARY

Job Number: 37592B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GR

ml 08/03/25

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/26

Job Completion



u 08/03/26

POSITIVE RECALL

EFFECTIVE 08.02.27 AUTH u

RELEASED 08.03.26 DATE u

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

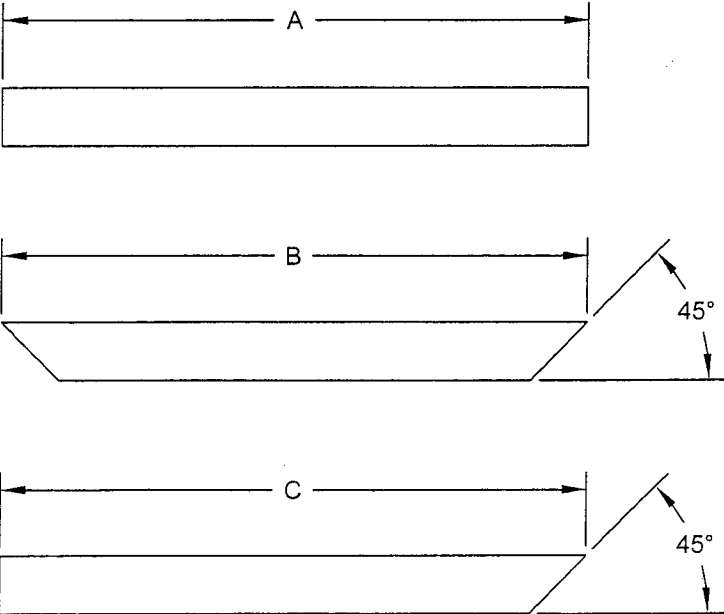
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	LENGTH C	DESCRIPTION
D2232-3 ✓	2	N/A	N/A	N/A	HINGE PLATE
D2327-3 ✓	2	N/A	N/A	N/A	BUSHING
D2581 ✓	2	N/A	N/A	N/A	MOUNTING BRAKET
D3442-1 ✓	2	N/A	N/A	N/A	SHIM
D3516-1 ✓	2	—	102.00	—	RIB
D3516-3 ✓	2	—	—	2.70	RIB
D3516-5 ✓	8	26.75	—	—	RIB
D3516-7 ✓	3	45.50	—	—	RIB
D3516-9 ✓	4	N/A	N/A	N/A	RIB (MAKE FROM D2235-3)
D3516-11 ✓	6	N/A	N/A	N/A	CLEVIS
D3516-13 ✓	4	N/A	N/A	N/A	CLEVIS
D3516-15 ✓	2	—	—	19.32	RIB
D3725-1	2	N/A	N/A	N/A	HOOP



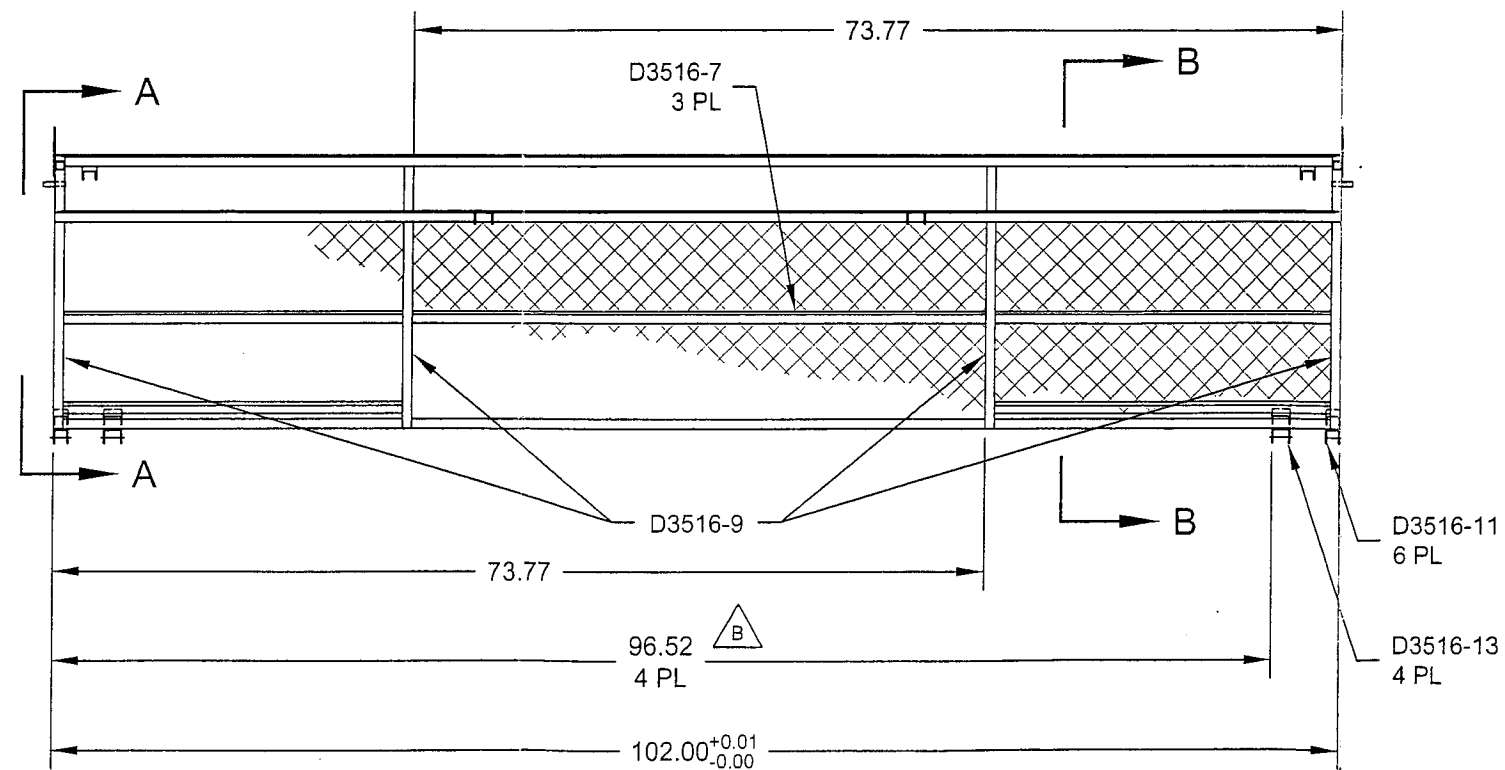
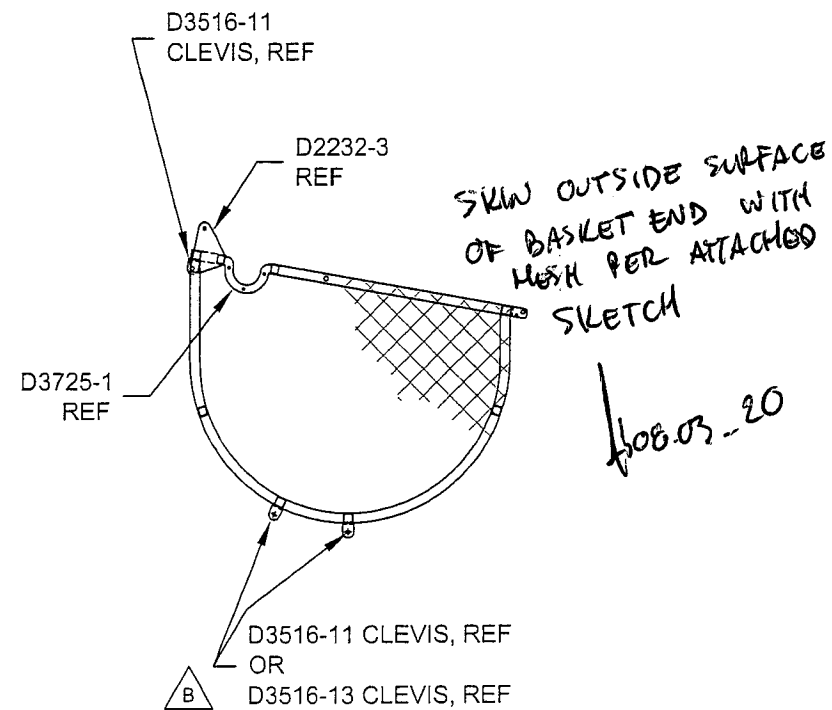
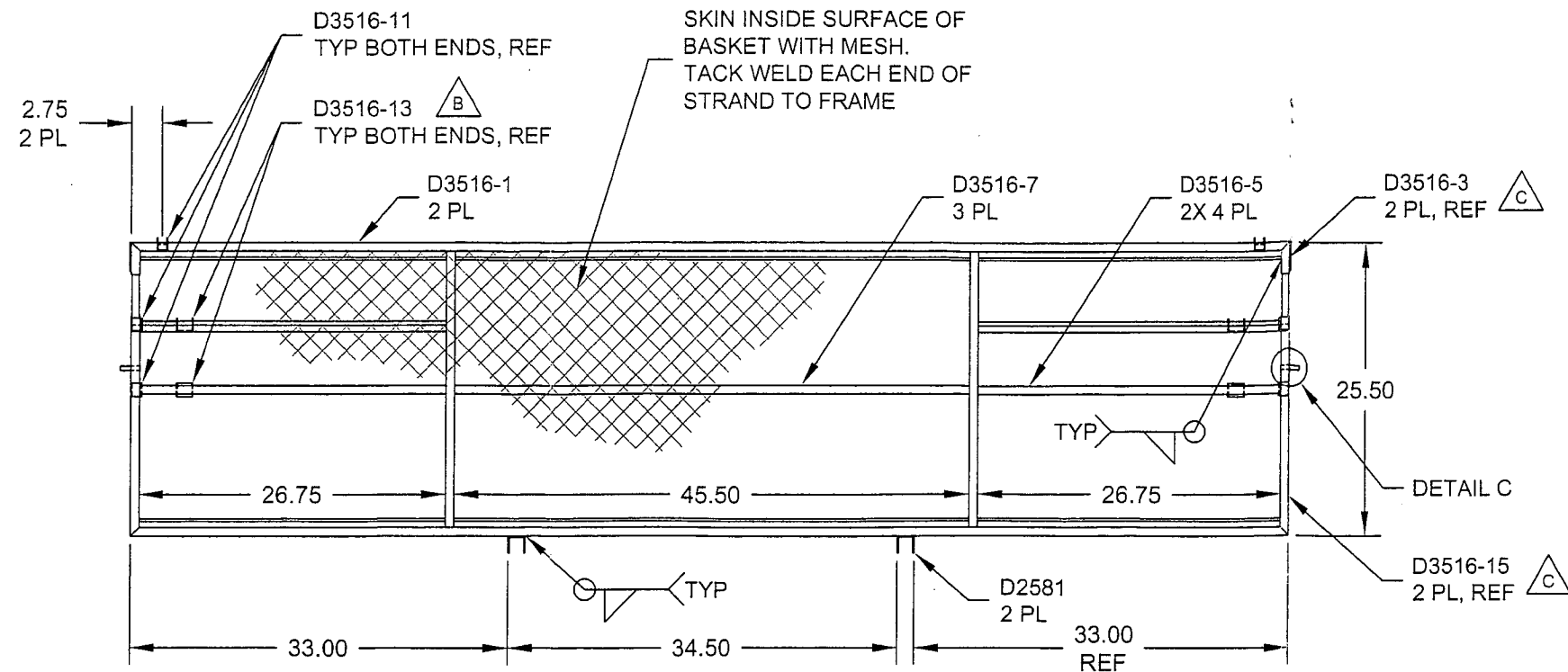
D3615-041 BASKET BASE ASSEMBLY NOTES:

- 1) MATERIAL:
FRAME - AISI 304/316 STAINLESS STEEL SQUARE TUBING, 3/4 X 3/4 0.065 WALL
(REF. DART SPEC. M304TS0.750W.065)
MESH - 3/4-16F EXPANDED STAINLESS STEEL
(REF. DART SPEC. M304EX0.75-16F)
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 75 lbs
- 8) WELDING: PER DART QSI 004

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WORK ORDER
NO. 37592 B

PRELIMINARY ISSUE

C	ADD D3725-1 (ZNA7-3) AND D3516-15 (ZNA5-3), QTY.(1) PER END OF BASKET BASE; SHORTEN D3516-3 (REF. ECN#1136); REASON: CUSTOMER REQUEST	MB	08.02.20
B	ADD QTY.(4) D3516-13; QTY.(8) D3516-11 WAS QTY.91) SEE TR-D119-756-1 REV. A	MB	06.07.25
A	NEW ISSUE	MB	06.06.21
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
DATE	08.02.20	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

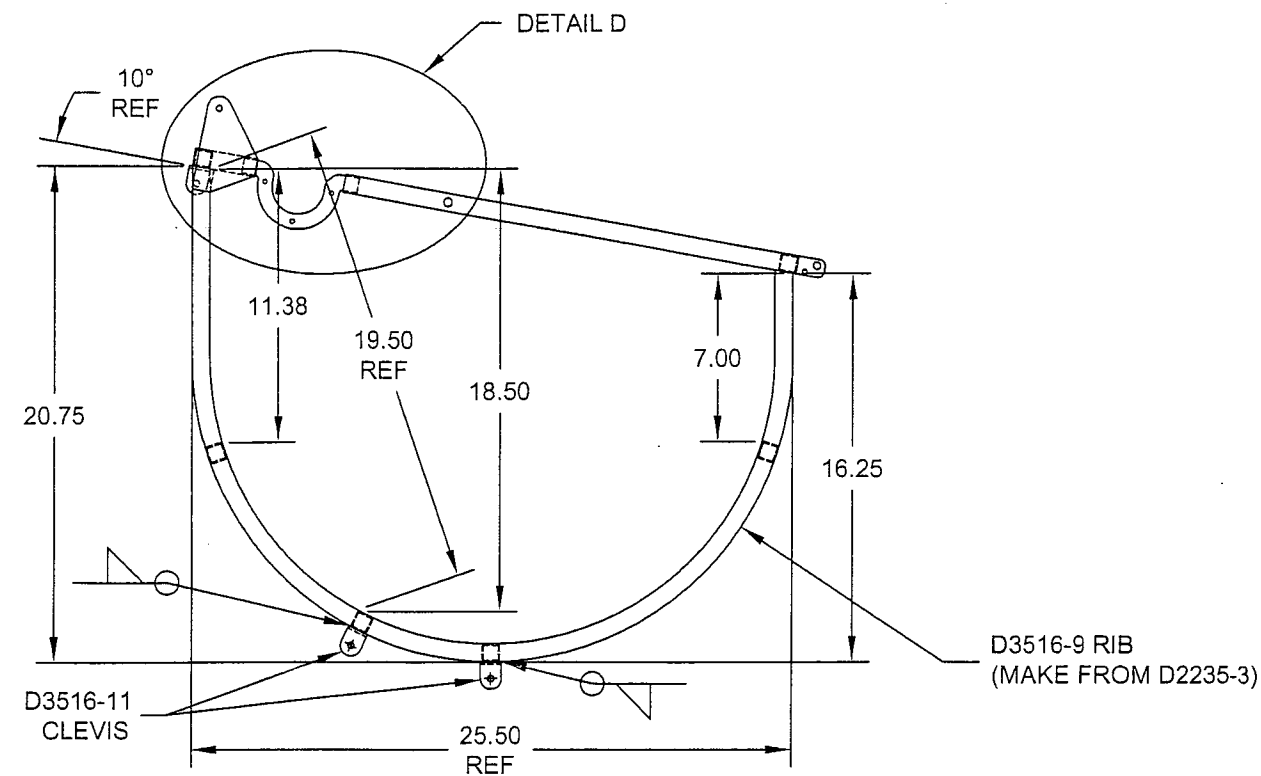


D3516-041 BASKET BASE ASSEMBLY

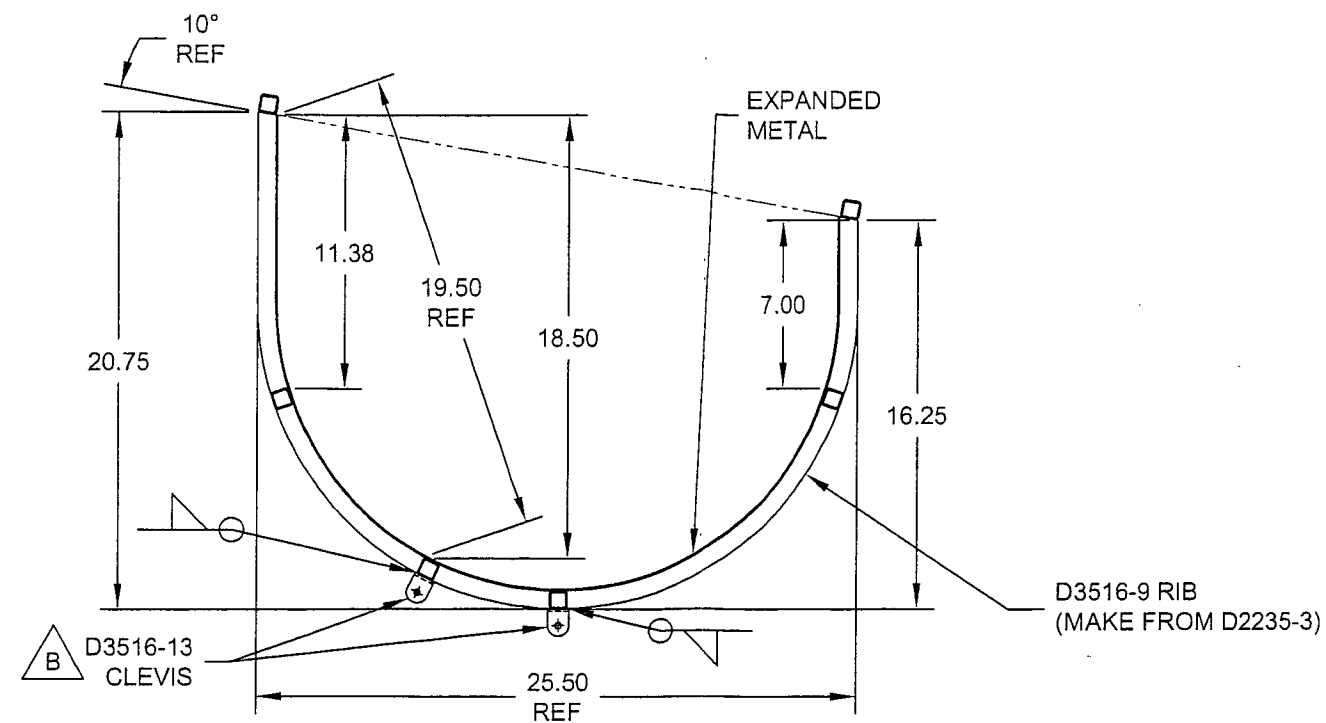
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NO. 375928

PRELIMINARY ISSUE
10.02.22

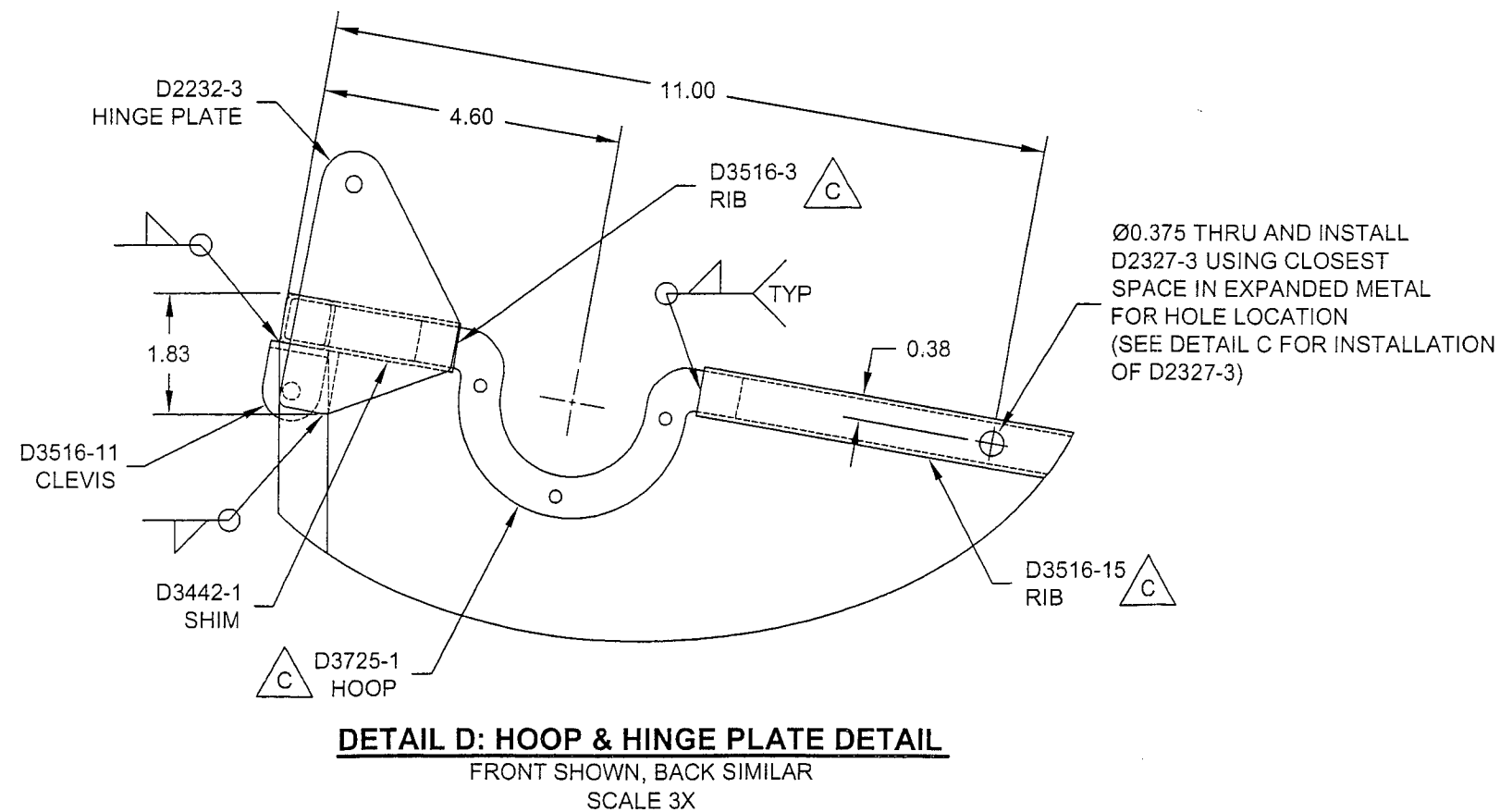
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (A119)	NTS
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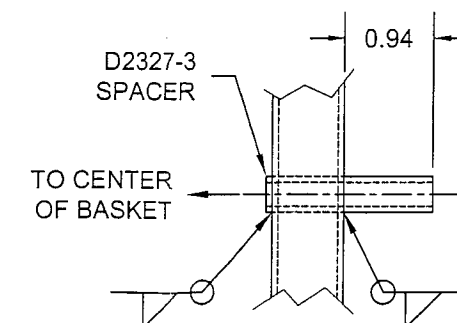
SECTION A-A: END RIB DETAIL
TYP BOTH ENDS



SECTION B-B: CENTER RIB DETAIL
2 PL



DETAIL D: HOOP & HINGE PLATE DETAIL
FRONT SHOWN, BACK SIMILAR
SCALE 3X

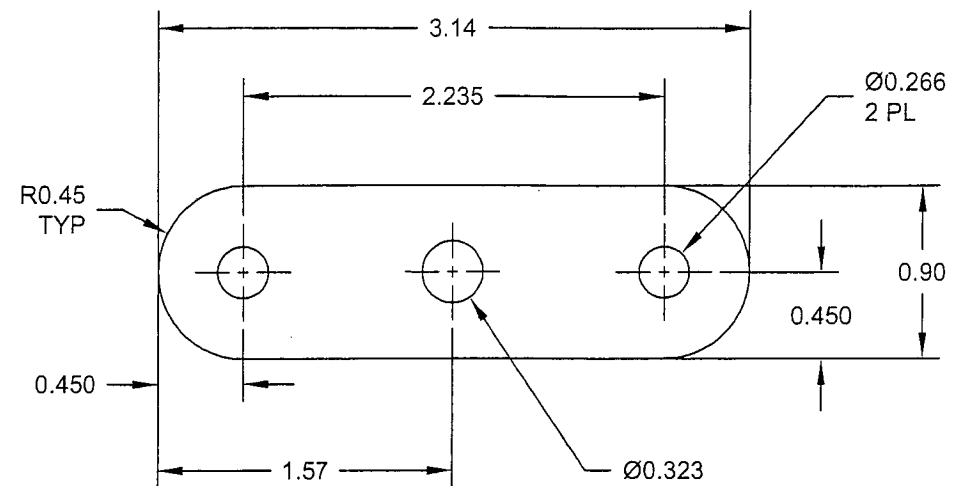


DETAIL C: SPACER INSTALLATION
SCALE 4X

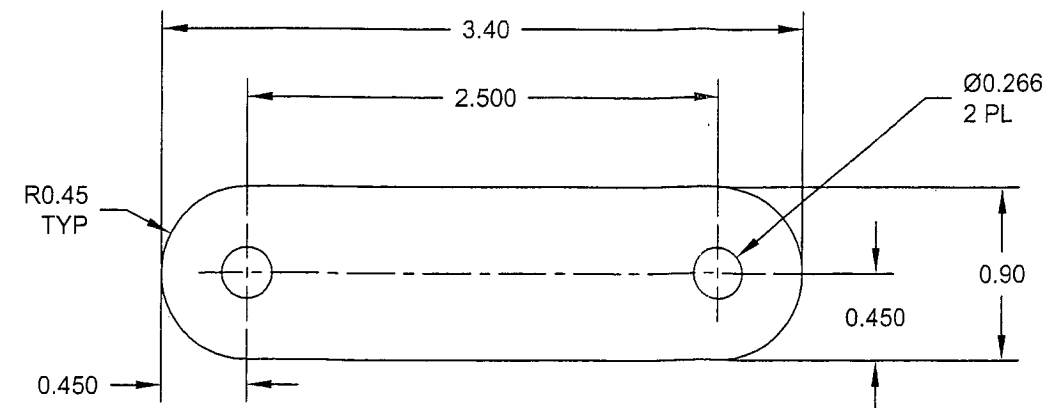
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PRELIMINARY ISSUE 08.02.20

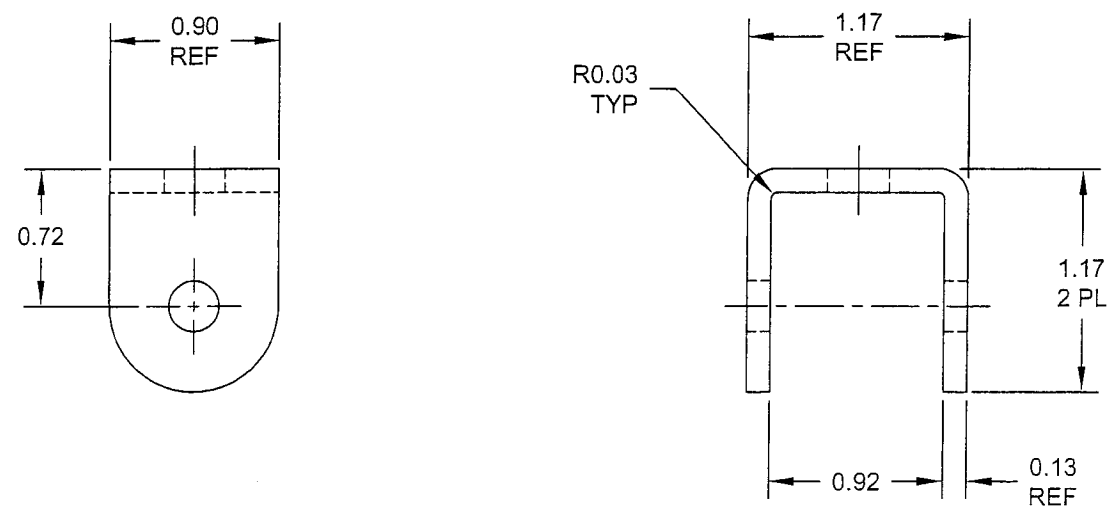
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	PA	DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY	NTS
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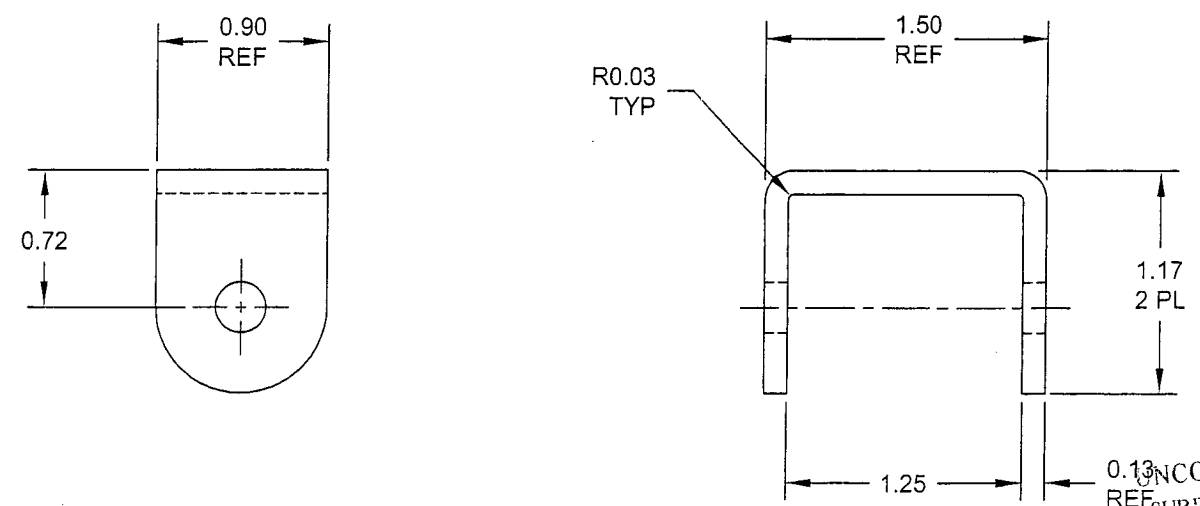
1 D3516-11F CLEVIS FLAT PATTERN



1 D3516-13F CLEVIS FLAT PATTERN



D3516-11 CLEVIS BENDING DETAIL
(MAKE FROM D3516-11F)



D3516-13 CLEVIS BENDING DETAIL
(MAKE FROM D3516-13F)

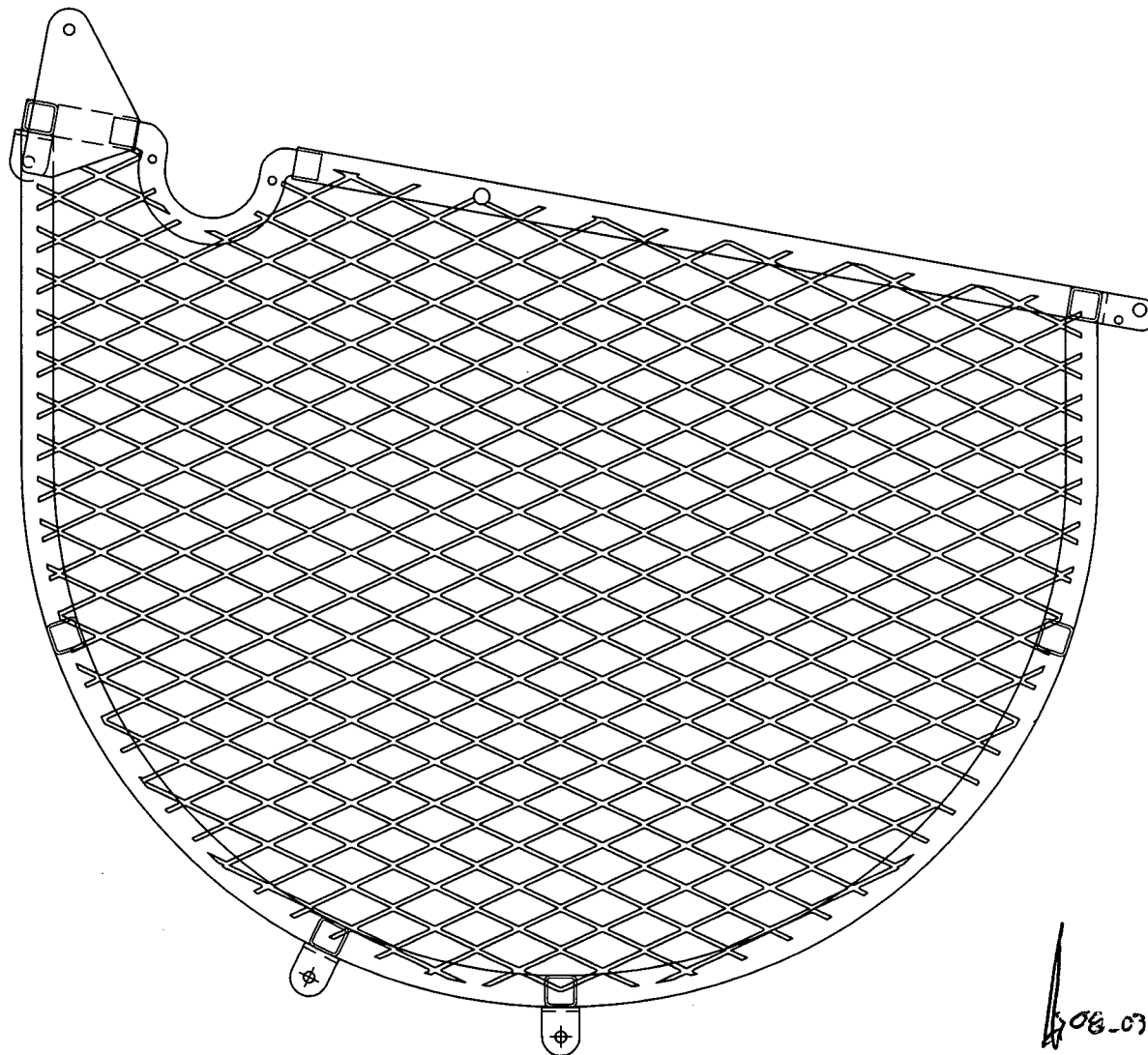
D3516-11/-13 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR AMS 5524, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3516-11 = 0.09 lbs
D3516-13 = 0.10 lbs

PRELIMINARY ISSUE

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NO. 37592B

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3516	SHEET 4 OF 4
APPROVED		TITLE	SCALE
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NO. 37592 B

08-03-20

12

Date: Monday, 2/25/2008 11:16:11 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASS'Y (A119)
Job Number	: 37592A		
Estimate Number	: 12445		
P.O. Number	:	Part Number	: D3515041
This Issue	: 2/25/2008 S.O. No. :	Drawing Number	: D3515 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37591A	Material	:
Written By	:	Due Date	: 3/17/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>08 02 26</u>		
Comment	: EST rev A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D22321	Hinge
-----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: B35684

PD 08-03-13

2.0	D31663	Basket Hoop
-----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: B36860

PD 08/03/12

3.0	D23271	Spacer Bushing
-----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: B31693 -> 1 B36920 -> 1

PD 08-03-13

4.0	D2506	Placard
-----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: B35585

PD 08-03-13

5.0	D2581	Mounting Bracket
-----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: B36481

PD 08-03-13

W/O#		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR#		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:16:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 37592A

Part Number: D3515041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0 M304TS0750W065 304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)
AISI 304 SQ Tube.75x.75x.065W
Batch: M107315

JS 08/03/12

7.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Cut rib D3515-1 (2) as per dwg D3516
2-Cut rib D3515-3 (2) as per dwg D3516
3-Cut rib D3515-5 (6) as per dwg D3516
4-Cut rib D3515-7 (3) as per dwg D3516
5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

JS 08/03/12

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Weld assembly as per dwg D3515

JS 08-03-13

9.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

JS 08/03/18

10.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)
Expanded Metal Flat Stainless steel
Batch: M107316

INSTALL HIGH PER MARKUP ON
SHEET 2 OF 4


JS 08.03.19
FC 0803 20

11.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut expanded metal for base as per dwg D3516 *FC*
2-Cut expanded metal for base ends as per dwg D3516 *FC*
3-Weld expanded metal to base as per dwg D3516 *FC*

08 03 20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08.03.19	10.0	SEE INSTRUCTIONS AT STEP 10.0.				 08.03.19	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/25/2008 11:16:11 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 37592A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 08-03-20

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 08-03-20

14.0

POWDER COATING

POWDER COATING



M10700S



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M.H.

08/03/24

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HD



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-24

(X1)

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D3515 and QSI 005 4.4 and spray paint as per dwg

wing walk: M107385

black spray paint: M107230

HD

08-03-25

(X1)

17.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



D.

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BK 08-03-25

18.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

ml 08/03/25

19.0

QC21

FINAL INSPECTION/W/O RELEASE



D.

Comment: FINAL INSPECTION/W/O RELEASE

PD 08/03/26

Job Completion



U 08.03.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

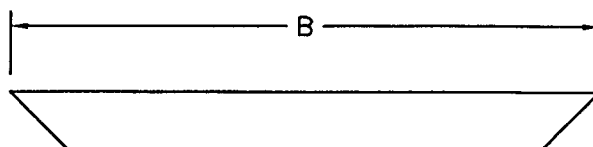
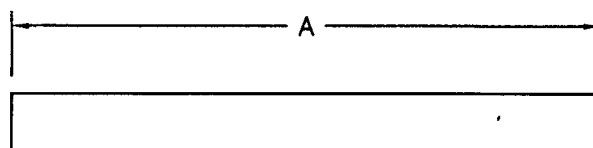
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED06.11.17 *[Signature]***PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY**

PART NO	QUANTITY	LENGTH		DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



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NO. **37592A**

D3515-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

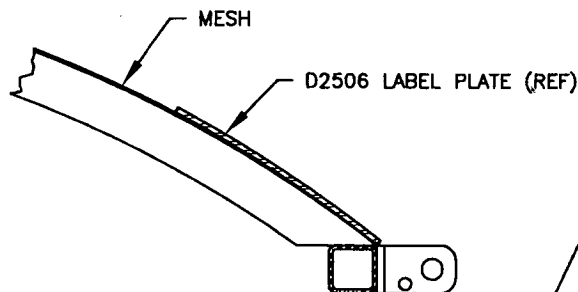
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06.11.17



SECTION A-A

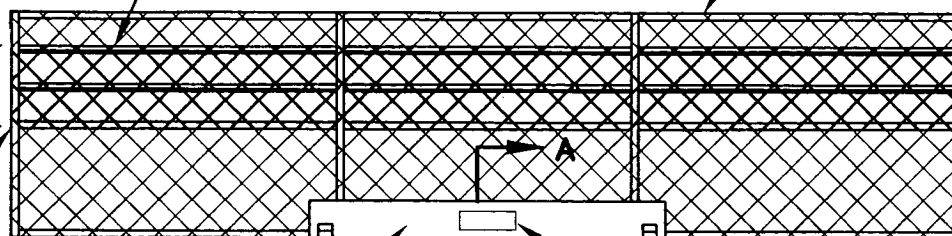
(ROTATED 90° CCW)

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT

TACK WELD MESH TO
FRAME AT EVERY AVAILABLE
LOCATION IN AREA TO BE
ANTI SKIDDED

SKIN OUTSIDE SURFACE OF LID WITH
3/4-16F EXPANDED SS. TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY



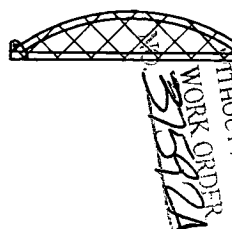
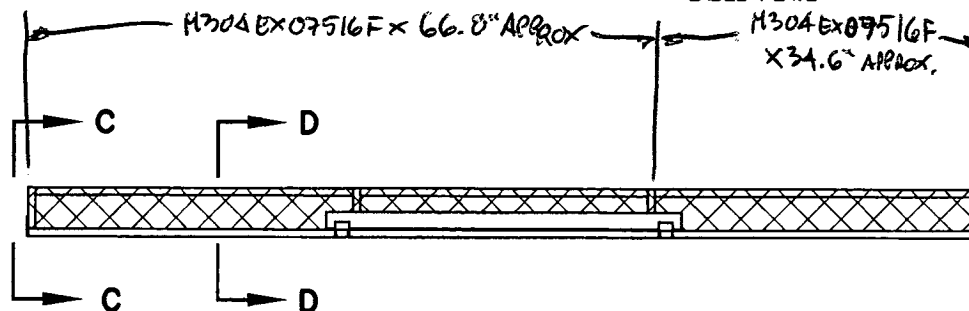
D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

M304EX0.7516F X 66.8" APPROX

M304EX0.7516F
X 34.6" APPROX

08.03.19



D3515-041 BASKET LID ASSEMBLY

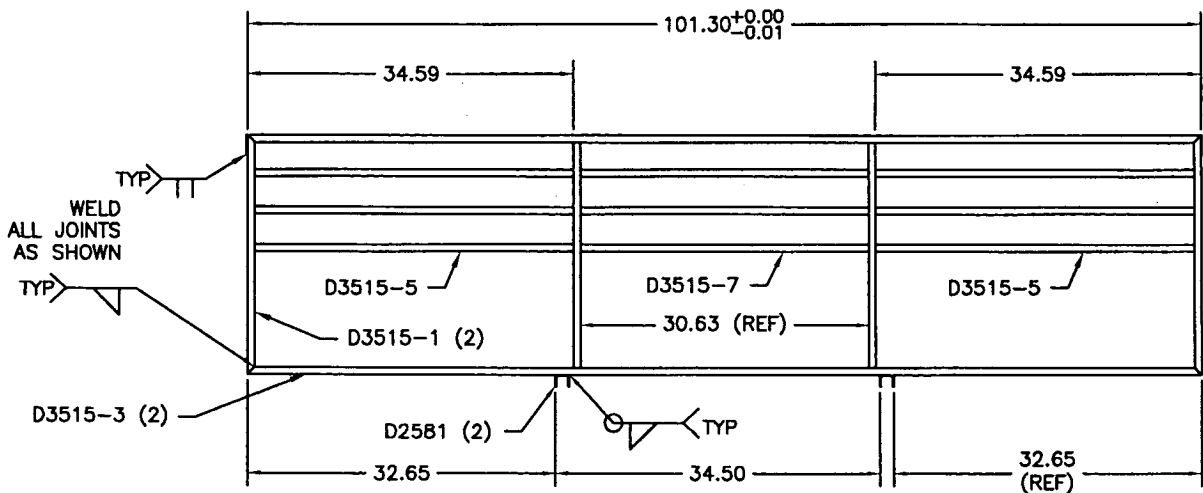
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. A
06.05.05	D3515	SHEET 2 OF 4
	TITLE	SCALE
	BASKET LID ASSEMBLY (A119)	1:20

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315924

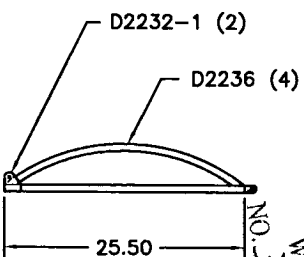
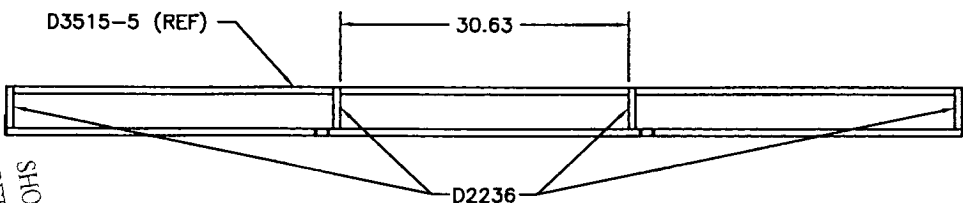
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3515	SHEET 3 OF 4
06.05.05		TITLE	SCALE
		BASKET LID ASSEMBLY (A119)	1:20



DETAIL B

FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

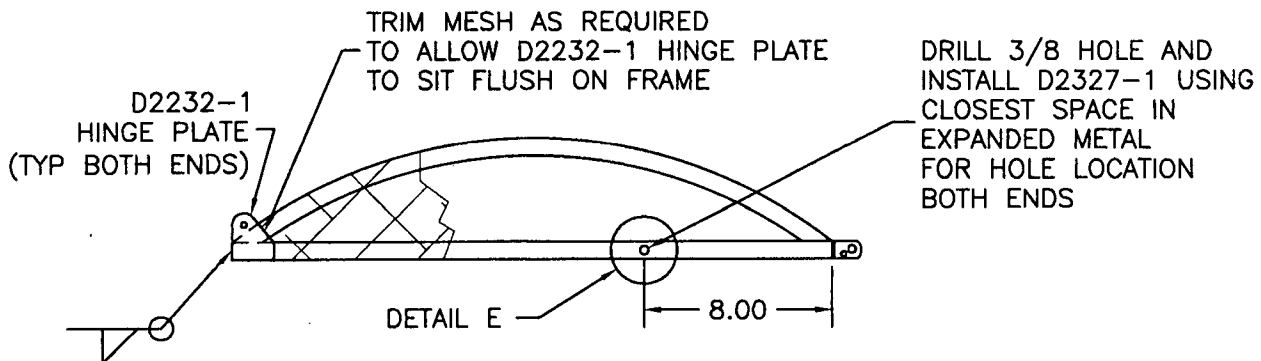


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06.11.17

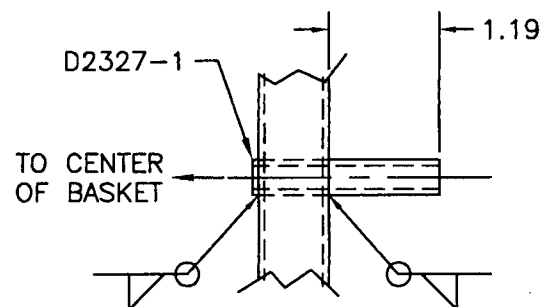


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

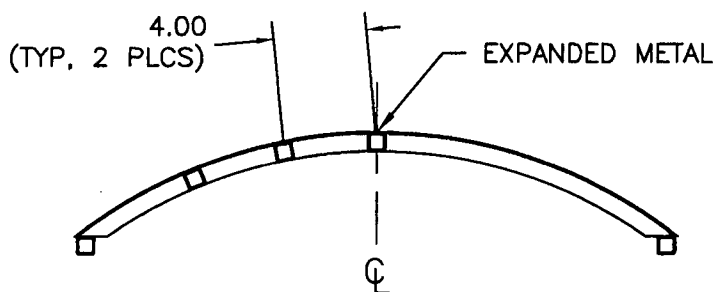


SECTION C-C SIMILAR BOTH END RIBS

RELEASED
06-11-17 *[Signature]*



DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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